controlling the amount of coating that goes onto the mat; the rest of the coating falls back into the tub. The illustrated process does not use a nip roll with the inking roll. The height of the inking roll, and the resulting position of the mat, is controlled so that the mat does not wrap on the lower squeeze roll.

In the embodiment shown in Fig. 7, the first coating is supplied by feeding the first coating to the nip 100 between the mat 50 and the lower squeeze roll 96. The first coating can be fed to the nip by any suitable means. Preferably, it is fed to the nip via a trough (not shown) that seals against the lower squeeze roll. The trough may be kept overflowing by filling on one side and flowing over a weir on the other.

Referring to Figs. 6 and 7, in a second coating operation, indicated generally at 102, a second asphalt-based coating 76 is continuously applied to the top surface 54 of the mat 50 in a manner so that the second coating forms a layer on the top surface. The second coating has different properties from the first coating. In the embodiment shown, the second coating is applied to the mat with an applicator roll 104. In the illustrated embodiment, the second coating operation also employs a metering roll 106 positioned beside the applicator roll with a gap 108 therebetween. The second coating 76 is supplied above the gap and flows through the gap onto the applicator roll for application to the mat. The size of the gap between the applicator roll and the metering roll controls the thickness of the second coating on the mat. Preferably, a device (not shown) to scrape the second coating from the surface of the applicator roll and smoothly apply it to the mat is positioned in the nip between the applicator roll and the mat.

Preferably, the applicator roll rotates in a direction so that the surface of the applicator roll adjacent the mat moves in the same direction as the mat, and the surface of the applicator roll moves at a speed within a range of from about 90% to about 110% of the speed of the mat. The metering roll rotates in a

counterclockwise direction so that the moving surface of the metering roll holds the second coating above the gap. Preferably, the mat at least slightly wraps on the applicator roll to promote wetting and transfer of the second coating to the mat. In the illustrated embodiment, the mat moves over a rounded exit support 88 which is positioned to cause a slight wrap of the mat on the applicator roll. Preferably, the second coating operation employs a device (not shown) to scrape the second coating from the surface of the applicator roll and smoothly apply the coating to the mat.

In an alternate embodiment of the second coating operation (not shown), the applicator roll rotates in a direction so that the surface of the applicator roll adjacent the mat moves in a reverse direction relative to the mat movement. The metering roll is positioned on the other side of the applicator roll, and it rotates in a clockwise direction. A metering bar is positioned at a 10 o'clock position relative to the applicator roll, controlling the thickness of the coating. No device is needed to scrape the applicator roll, as the mat wipes all the coating off. Preferably, the speed of the applicator roll is about 30 - 50% of the speed of the mat, in the reverse direction. One skilled in the art appreciates that the speed may be adjusted to vary the thickness, a slower speed will result in a thicker coating, and a faster speed will result in a thinner coating, and increase the sheet tension.

The principle and mode of operation of this invention have been described in its preferred embodiments. However, it should be noted that this invention may be practiced otherwise than as specifically illustrated and described without departing from its scope.